

# Work Order ID 73386

Wednesday, August 31, 2011 1:26:15 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 8/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CH Date: 11/08/31

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2750	F
-------	---

D3492	C
-------	---

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

8 u/c/28

for MLJ 11-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Skidtubes

Skidtubes

0.00

Skidtubes

**Memo**

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

11/10/20

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: ☐ M11836

8/11/10/20

12-Grind welds flush as per Dwg D2750

BB 11/10/21

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/11/10/21

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/10/21

(40)

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

① S40 11-10-22

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

JP 11-10-22

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> Sikaflex-291 batch: <u>M118 393</u> exp. date: <u>12-4-5</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> Aluminum Rod batch: <u>M118 736</u> <u>BE 11/10/24</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404" <u>BE 11/10/24</u>								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

11-10-2211/10/24

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Sulco b5

3 11/10/24

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sulco b5

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 BR 11-10-25

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:30

OVEN TEMPERATURE: 3200F

FINISH TIME: 2:00

1 X 11/10/25

210 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 BR 11-10-27

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00



HandFinishing

1 BL 11-10-21.

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"  
batch: N/A.

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750  
SIKA FLEX 241  
BATCH: 118393  
EXP DATE: 12-5.

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 110348.

6-Coat all exposed fasteners with "LPS Procyon"  
batch: 114396.

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

8/31/27



QC

Memo

0.00

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Sp 11-10-28

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/31/28

W/O:		WORK ORDER CHANGES					
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Stop



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270	Packaging	0.00							
	Packaging								
	Memo	0.00							
	Package as per PPP D350-636-012								
280	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

*PPPP/28*

*11/10/31*

*mf*

*11-10-28*

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 1

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Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07-13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as per  
 IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS4-1032-225

Purchased

No

Each

1,925.000

38



BR 11-10-27

Insert

Location

Loc Qty

Loc Code

ST282

1925

110768

62

117717

9

118386

860

118696 ✓

994

38

AN3C5A

Purchased

No

230

Each

1,261.000

34

34



BR 11-10-27

Bolt

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1254

116419

28

116549

30

117343

462

117764

222

117872

12

118451 ✓

500

34

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Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

328.0000

4

4



BOLT



BR 11-10-27.

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

327

111982

2

116419

23

116549

2

116704

12

117619

22

117688

16

117872

50

118422 ✓

200

4

AN6C44A

Purchased

No

230

Each

115.0000

4

4



BOLT



BR 11-10-27.

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

113

117950

13

118112

2

118332

48

118387 ✓

50

4.

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, August 31, 2011 1:26:12 PM

Work Order ID: 73386

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

131.0000

1

1



BOLT



BR 11-10-27

Location

Loc Qty

Loc Code

FP

95

117511 ✓

29

118286

66

FP-A

1

115960

1

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

AN960C10L

NAS1149C0332  
R

Purchased

No

230

Each

0.0000

38

38



washer

D2745

Manufactured

No

230

Each

309.0000

8

8



Bushing



38

BR 11-10-27

118354

Location

Loc Qty

Loc Code

FP-A

147

69529

147

ST023

162

71835 ✓

162

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 1:26:12 PM

Work Order ID: 73386



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

17.0000

1

1



Blade Fitting Assembly, RH



BR 11-10-27.

Location

Loc Qty

Loc Code

FP008

71883

17

62003

1

68109

7

69904

9

D3492-1

Manufactured No

230

Each

72.0000

8

8



Plug



BR 11-10-27.

Location

Loc Qty

Loc Code

FP

73402

72

69531

8

71836

64

D3492-3

Manufactured No

230

Each

161.0000

8

8



Plug



BR 11-10-27.

Location

Loc Qty

Loc Code

FP

74447

161

70692

4

71838 ✓

100

72126

57

D3535-25

Manufactured No

230

Each

16.0000

1

1



Wearshoe



BR 11-10-27.

Location

Loc Qty

Loc Code

FP018

74592

16

62233

1

69743

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 1:26:12 PM

Work Order ID: 73386

Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 8/31/2011



Required Date: 9/15/2011

Start Qty: 1.00



Required Qty: 1.00

D3536-25	Manufactured	No	230	Each	18.0000	1	1	
								
Gasket								BR 11-10-27.



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012 74526.	18	1
70780	18	

D3537-1	Manufactured	No	230	Each	117.0000	3	3	
								
Wearpad								BR 11-10-27.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001 74597	60	3
72124	60	
FP016	50	
68944	0	
70687	50	
FP017	7	
69817	5	
70686	2	

D3631-1	Manufactured	No	230	Each	251.0000	8	8	
								
Washer								BR 11-10-27.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST072	251	8
68062 ✓	251	

D3791-1	Manufactured	No	230	Each	10.0000	1	1	
								
Wearplate								BR 11-10-27.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017 74527	10	1
62239	2	
69282	8	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 1:26:12 PM

Work Order ID: 73386

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-1 Manufactured No

230

Each

16.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018 73422  
70781

16  
16



1

BR 11-10-27.

D3793-3 Manufactured No

230

Each

22.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP018 74573  
70813  
72160

22  
10  
12



1

BR 11-10-27.

D3794-1 Manufactured No

230

Each

20.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP010 74529  
70779

20  
20



1

BR 11-10-27.

D3794-3 Manufactured No

230

Each

11.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP018 73423  
70812

11  
11



1

BR 11-10-27.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 7

Wednesday, August 31, 2011 1:26:13 PM

Work Order ID: 73386

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

577.0000

4

4



NUT



BR 11-10-27.

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

557

112314 ✓

347

117887

10

118384

200

11.

MS21083C8

Purchased

No

230

Each

121.0000

1

1



NUT



BR 11-10-27.

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

35

118077

35

ST303

85

115884

0

117423

5

118354

30

118614 ✓

50

1

NAS1149C0832R

Purchased

No

230

Each

363.0000

1

1



WASHER



BR 11-10-27.

Location

Loc Qty

Loc Code

FP-B

33

114915 ✓

33

ST297

330

114915

330

1

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 1:26:13 PM

Work Order ID: 73386

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

228.0000

4

4



WASHER



BR 11-10-27

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

188

113362 ✓

88

118686

100

41

NAS1611-010

Purchased

No

230

Each

238.0000

8

8



O-RING



BR 11-10-27

Location

Loc Qty

Loc Code

FP

221

117460

8

118077

13

118612 ✓

200

FP-A

17

110915

14

115589

3

8

NAS1611-013

Purchased

No

230

Each

216.0000

8

8



O-RING



BR 11-10-27

Location

Loc Qty

Loc Code

FP

55

117291

2

117887

53

FP-A

161

116582

5

118284 ✓

156

8

BR 11-10-27

~~8~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 1:26:13 PM

Page 9

Work Order ID: 73386

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased No

250

Each

59.0000

2

2

BOLT

Location

Loc Qty

Loc Code

ST344

9

117764

9

ST345

50

118045

50

D2741

Manufactured No

250

Each

10.0000

1

1

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

10

69133

10

D3493-1

Manufactured No

250

Each

89.0000

2

2

Washer

Location

Loc Qty

Loc Code

ST062

89

70697

49

71846

40

D3532-1

Manufactured No

250

Each

17.0000

2

2

Spacer

Location

Loc Qty

Loc Code

ST065

17

69895

17

Wednesday, August 31, 2011 1:26:13 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 1:26:13 PM

Page 10

Work Order ID: 73386

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

121.0000

2

2



NUT



m 119309 SP

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

35

118077

35

ST303

85

115884

0

117423

5

118354

30

118614

50

NAS1149D0863J

Purchased

No

250

Each

166.0000

2

2



WASHER



SP 11-1028

Location

Loc Qty

Loc Code

ST298

166

118078

166

D2600-3-BENT

Manufactured

No

110

Each

9.0000

1



Extrusion Bent



2x  
① 11/10/20 X

Location

Loc Qty

Loc Code

LG

75023

9

66875

8

72153

1

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Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, August 31, 2011 1:26:13 PM

Page 11

Work Order ID: 73386

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

81.0000

1

1



Cap



*BE 11/10/20*

Location

Loc Qty

Loc Code

LG002

25

62715

1

70881

24

WA

56

71861

56

*1*

D2739

Manufactured No

160

Each

7.0000

1

1



350 I Beam



Location

Loc Qty

Loc Code

LG

7

70823

7

*72156*

*① DP 11-10-22*

D2743

Manufactured No

160

Each

232.0000

8

8



Crossbolt Spacer



*BE 11/10/20*

Location

Loc Qty

Loc Code

LG

174

69818

9

71839

165

LG001

58

67766

4

68251

54

*8*

D3490-3

Manufactured No

160

Each

30.0000

4

4



Cross Bolt Spacer



*BE 11/10/20*  
*B 73295*

Location

Loc Qty

Loc Code

LG

30

70768

30

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Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 12

Wednesday, August 31, 2011 1:26:13 PM

Work Order ID: 73386



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 8/31/2011

Required Date: 9/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

114.0000

4

4



Cross Bolt Spacer



*8/31/10/24*

Location

Loc Qty

Loc Code

LG

112

67773

5

69823

42

71841

65

LG001

2

62450

2

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*4*  
\_\_\_\_\_  
\_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 13386  
C211108131

RELEASED

F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RE		
CHECKED	MP	DRAWING NO.	REV. F
MFG. APPR.	MP	D2750	SHEET 1 OF 11
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

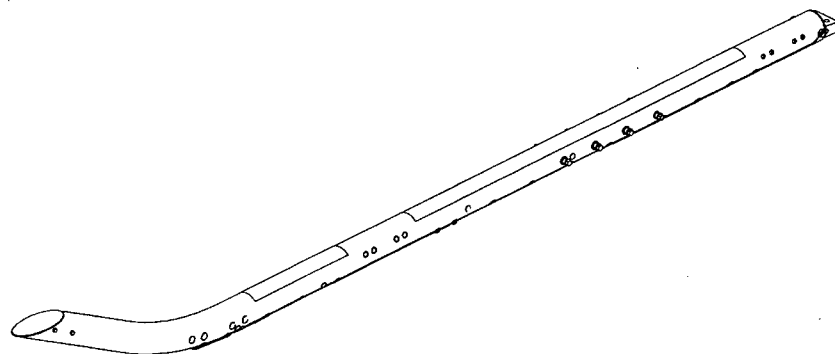
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

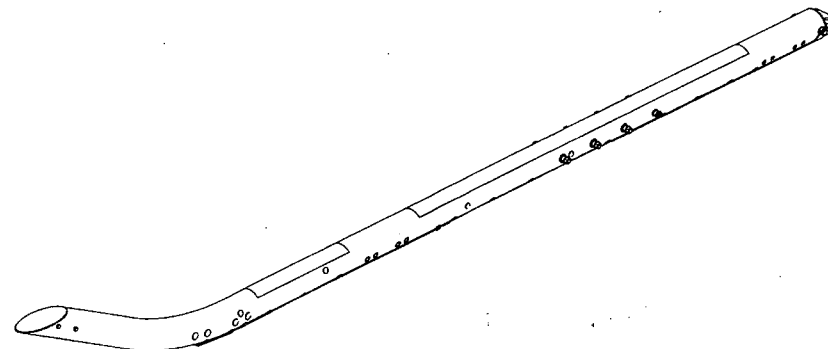
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
08-09-22-14

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	AM		
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	SA	D2750	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
DE APPR.	SA	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

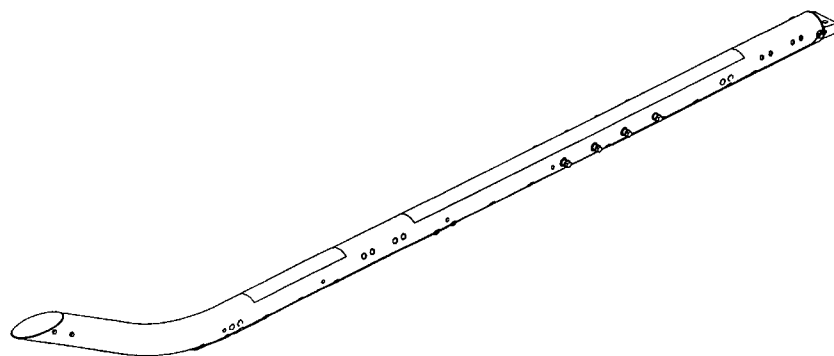
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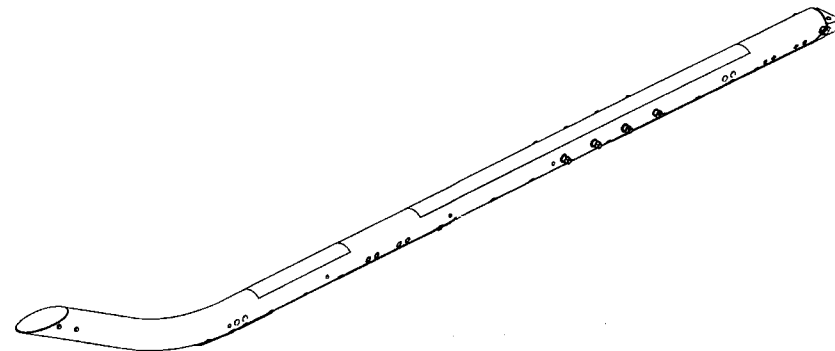
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
68-9-22/100

DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	M	D2750	SHEET 3 OF 11
APPROVED	M	TITLE	SCALE
DE APPR.	M	350 SKIDTUBE ASSEMBLY	NTS
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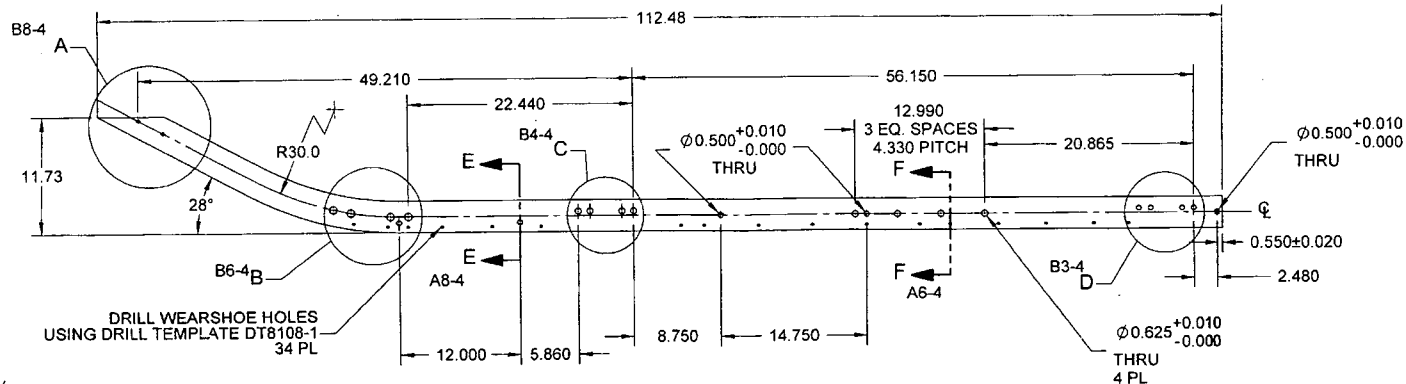
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

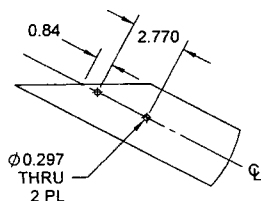
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

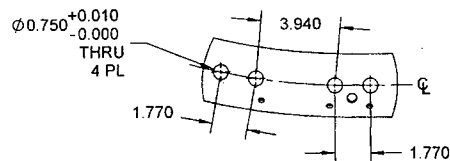
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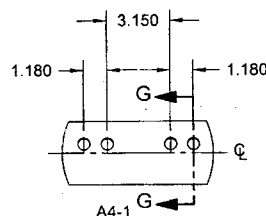
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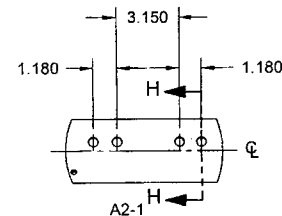
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SCALE 2X



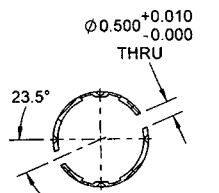
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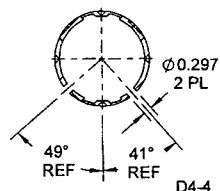
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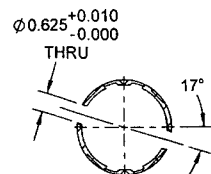
**DETAIL D**  
SCALE 2X



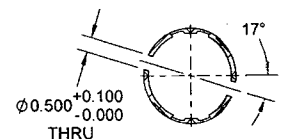
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

**RELEASED**

DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>
DRAWN	PA	PORT HADLOCK, WA
CHECKED		DRAWING NO. <b>D2750</b>
MFG. APPR.		REV. F
APPROVED		SHEET 4 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	08.07.16	SCALE <b>NTS</b>

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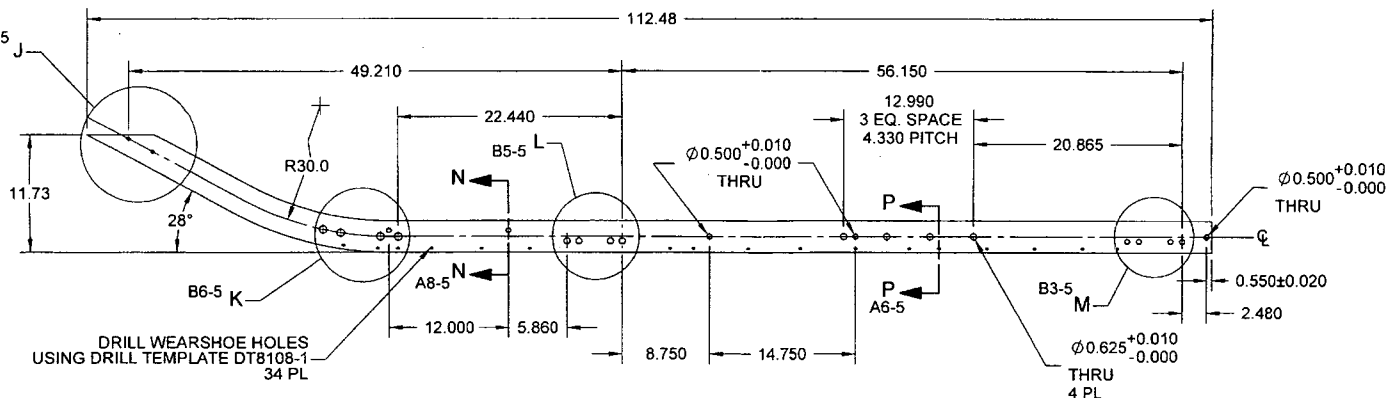
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

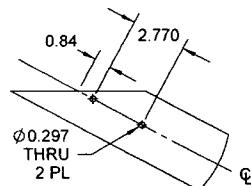
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

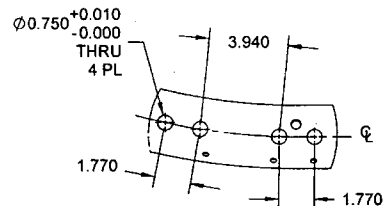
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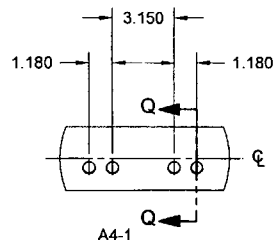
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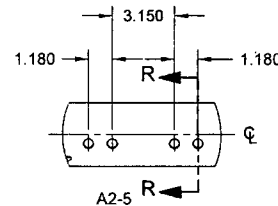
**DETAIL J**  
SCALE 2X



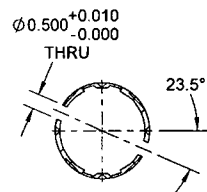
**DETAIL K**  
SCALE 2X



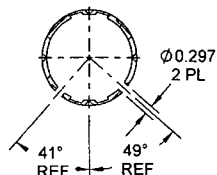
**DETAIL L**  
SCALE 2X



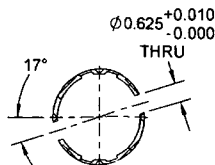
**DETAIL M**  
SCALE 2X



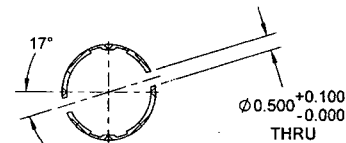
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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DESIGN	PL	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PL	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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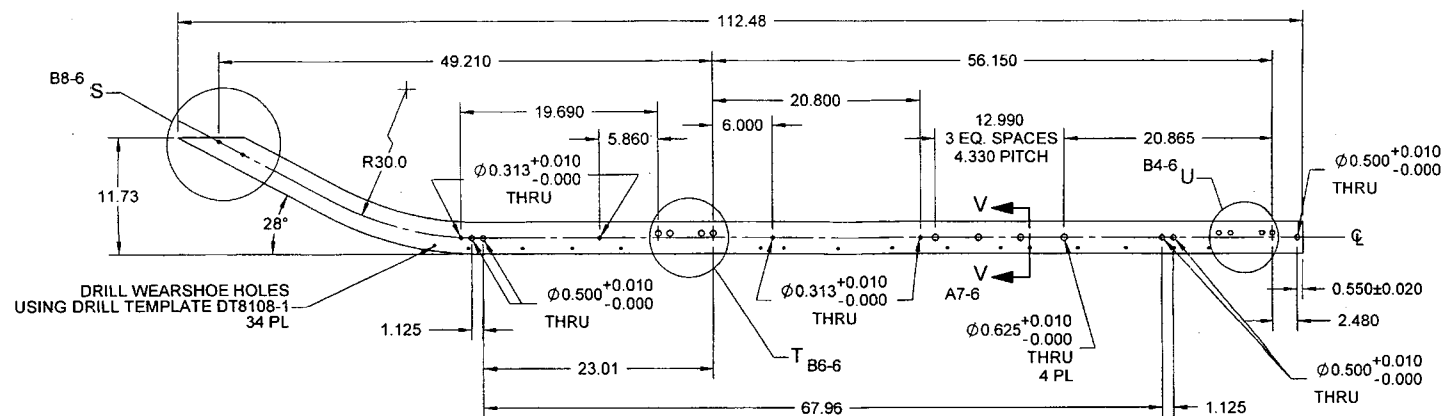
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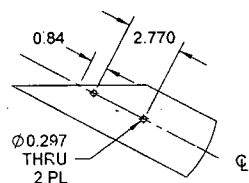
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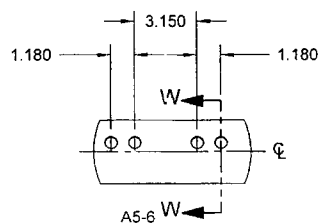
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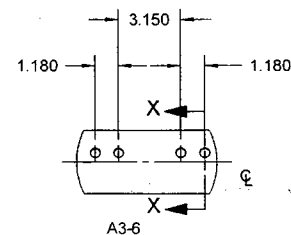
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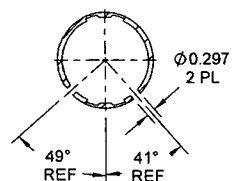
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SCALE 2X



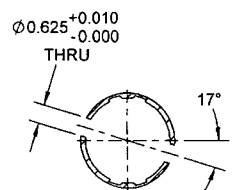
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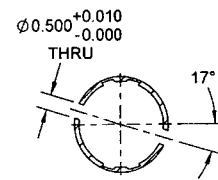
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

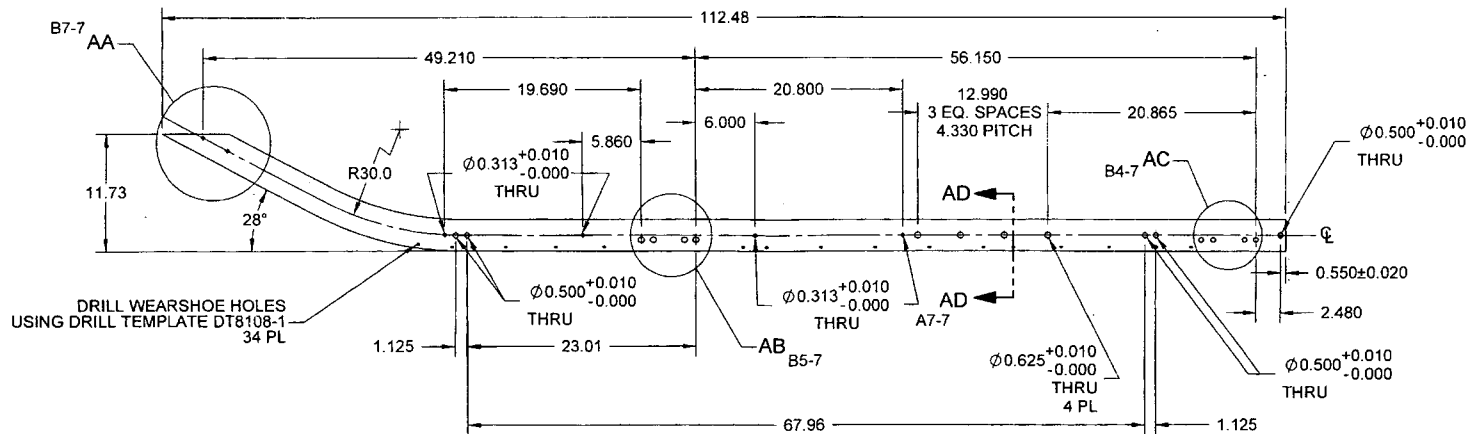
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

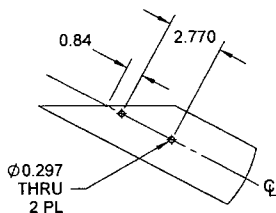
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

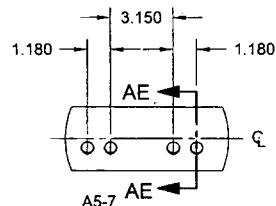




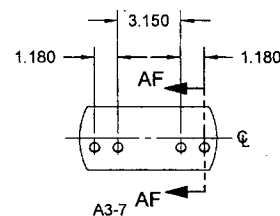
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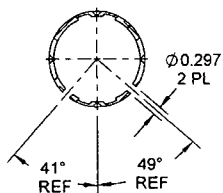
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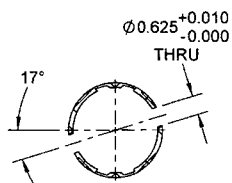
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SCALE 2X



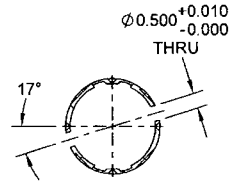
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

**RELEASED**  
060922/10

DESIGN		<b>DART AEROSPACE USA, INC.</b>
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. <b>D2750</b>
MFG. APPR.		REV. F
APPROVED		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DE APPR.		SCALE <b>NTS</b>
DATE	<b>08.07.16</b>	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.

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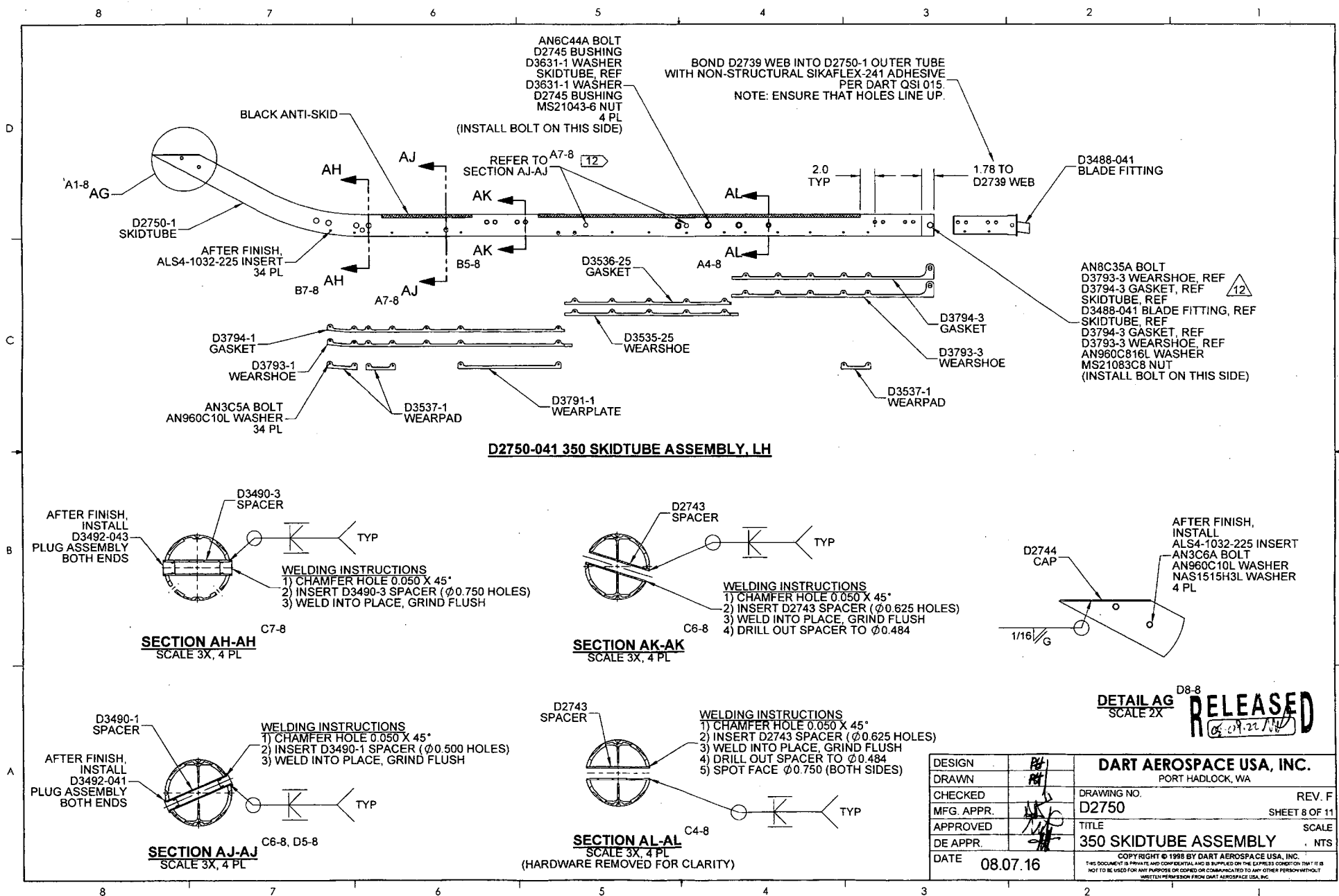
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



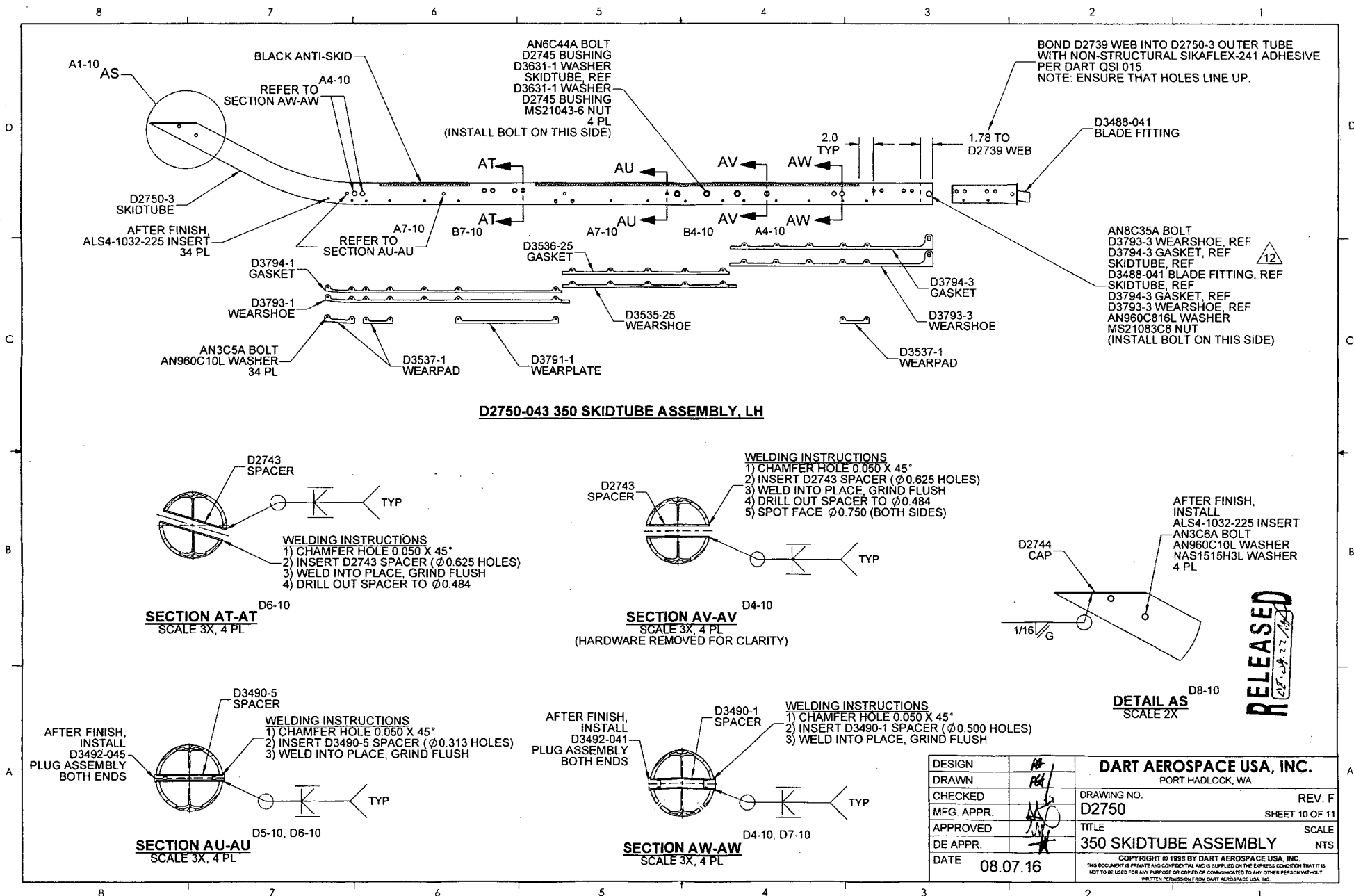
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

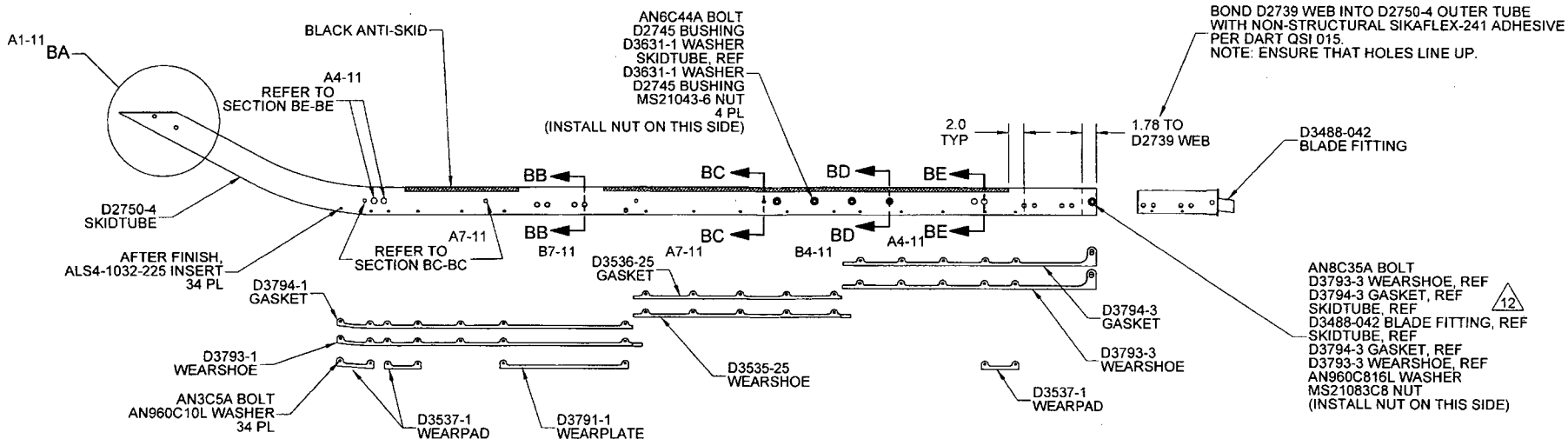
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

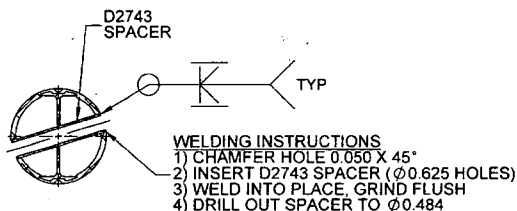
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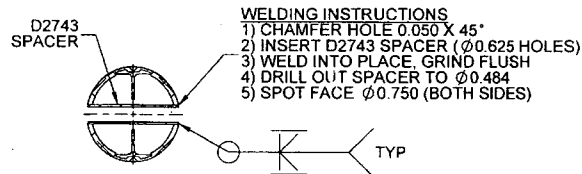
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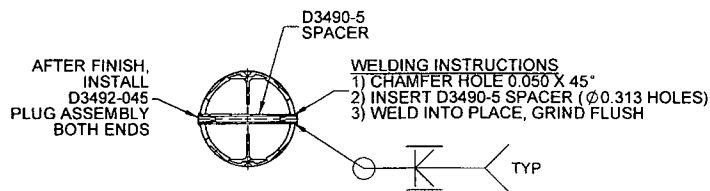
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



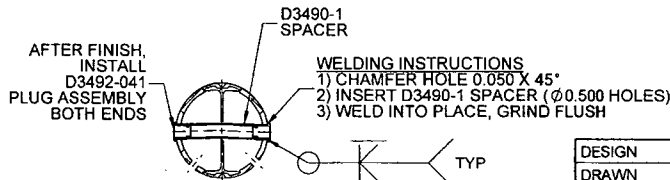
**SECTION BB-BB**  
SCALE 3X, 4 PL



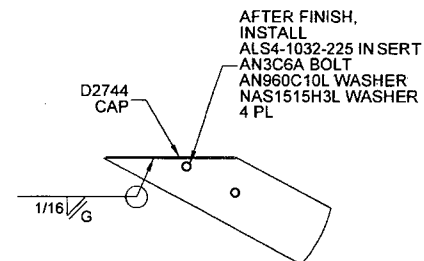
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

DESIGN	AS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	<b>D2750</b>	SHEET 11 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 270

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: B 72821  
Part number: D 350 636 012  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Dunn Date of Test Coupon 11-10-07  
Welder Barclay Elliott Date of Test Coupon 11-10-07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld